

Green

Dart Aerospace Ltd.

Date: Wednesday, 08/04/2009 10:47:49 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FWD BLADE FOLD ASSY WELDMENT
<b>Job Number</b>	: 47088		
<b>Estimate Number</b>	: 13418		
<b>P.O. Number</b>	:	<b>Part Number</b>	: PB674300107 GN
<b>This Issue</b>	: 08/04/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: B6743001 P.5
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 45052	<b>Drawing Revision</b>	: B1
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 25/04/2009
<b>Checked &amp; Approved By</b>	: <u>09-04-08</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:A 08-06-25 new issue DD verified by:ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PB674300147	Base Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Base Assembly  
 batch:- 47049

MF 09-04-29

2.0	PB6743001205	Outer Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Outer Tube  
 batch:- 45259

MF 09-04-29

3.0	PB6743001197	Outer Tube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Outer Tube  
 batch:- 41483

MF 09-04-29

4.0	PB6743001211	Square Tubing
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**Comment:** Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Square Tubing  
 batch:- 44989

MF 09-04-27

5.0	PB6743001209	Square Tubing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Square Tubing  
 batch:- 47093

MF 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 08/04/2009 10:47:49 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 47088

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001201

Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Tubing

batch:- 44990

MF 09-04-27

7.0

PB6743001203

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Tube

batch:- B41907

MF 09-04-27

8.0

PB6743001207

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Tube

batch:- B47490

MF 09-04-29

9.0

PB6743001219

Angled Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angled Male Eye

batch:- B41908

MF 09-04-27

10.0

D34405

Contoured Detent Clip Base (Supersedes B



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Contoured Detent Clip Base

batch:- B241454

MF 09-04-27

11.0

D34407

Detent Clip Base (Supersedes B67-43001-2



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Detent Clip Base

batch:- 41455

MF 09-04-27

12.0

D344015

Contoured Male Eye (Supersedes B67-43001



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Contoured Male Eye

batch:- 41453

MF 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 08/04/2009 10:47:50 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 47088

Part Number: PB674300107

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

\*\*\* ensure no burn thru after welding in tube -205 and -197 only where bushing -265 \*\*\*

PL 09-04-30 ①

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-01

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 09/05/01 ⑩

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*mask inside of D3440-5, D3440-7 and D3440-15 prior to paint\*\*\*\*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

11:30

OVEN TEMPERATURE:

320°

FINISH TIME:

12:00

FL 09/05/05 ⑪

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-05-5 ⑫

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MISC

PL 09-05-06 ⑬

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06 ⑭

Job Completion



MF 09-05-06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

1.8 NO PAINT THIS  
AREA ALL AROUND - 315  
3 PLACES

